

Work Order ID: 97456 - 2
February-20-13 10:20:08 AM

97456

Page 1

Item ID: D2616-1

Revision ID:

Item Name: Mounting Lug, EC 120 Step

Start Date: 2/20/13

Start Qty: 20.00

Required Date: 3/06/13

Req'd Qty: 20.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MCS

Date: 13-02-20 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2616

Rev E

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks: 2.000" long +0.030" -0.000"

0.00

0.00

OK 13/02/21

40 0
OK 13 02 27 (x40)

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per folio D2616-1 & DWG D2616 2-Tumble & Deburr

0.00

0.00

OK 13/02/21

40 0
OK 13 02 28 (x1)

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

OK 13/02/21

40 0
OK 13 02 28 (x1)

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Page 2

Item ID: D2616-1

Revision ID:

Item Name: Mounting Lug, EC 120 Step

Start Date: 2/20/13 Start Qty: 20.00

Required Date: 3/06/13 Req'd Qty: 20.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

130

130

QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

①

LB227

140

140

Hand Finish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

1 LB13-2-27

150

150

Powdercoat

Powder Coating

Grey Sandtex (Ref 4.3.5.6) per QSI005 4.3

M122966

Memo

Note: Mask large holes

TEMPERATURE: 300 START TIME: 10:00 FINISH TIME: 10:30

0.00

10:00

OVEN 10:30

1 LB13-2-27



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Page 3

Item ID: D2616-1

Revision ID:

Item Name: Mounting Lug, 1" C 120 Step

Start Date: 2/20/13 Start Qty: 20.00

Required Date: 3/06/13 Req'd Qty: 20.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

Small Fab

0.00

170

Small Fab

Memo

0.00

Small Fab

1-Coat bearing in light oil 2-Press Bearing in D2616-13-Stake as per Dwg D2616 using 13/0017-4- Touch up paint if required

Press dt 9472
Stake dt 9472

QC5- Inspect part completeness to step on W/O

0.00

180

180

QC

Memo

0.00

Quality Control

(Stake dt 24 on each side)
8/13/12/27

DAS
300
280

13/02/26

S

13/02/28

DAS
16
9-03 13/12/27

Work Order ID 97456

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97456

Page 4

Item ID: D2616-1

Revision ID:

Item Name: Mounting Lug L.C 120 Step

Start Date: 2/20/13 Start Qty: 20.00

Required Date: 3/06/13 Req'd Qty: 20.00

Reference:

Accept

N19000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

190

190

Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location:

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

1

8

13/2/27

200

200

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

MLJ 13-02-27

MLJ

13-2-27



Print

February-20-13 10:22:19 AM

Page 1

Work Order ID: 97456

Parent Item: D2616-1

Parent Item Name: Mounting Lug, EC 120 Step

97456

D2616-1

Start Date: 2/20/13

Start Qty: 20.00

Required Date: 3/06/13

Required Qty: 20.00

Comments:

IPP Rev: C00,06,22 Removed P/O for powder coat EC
IPP Rev: D 07-12-17 rev E as per dwg ECN 1069 DD verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per kit	Total Qty	Qty Issued	Date Issued	Status
D2611		Manufactured	No				Each	19.0000		20			
D2611									**				
Bearing													

SO 13/02/26

M6061T6B1.000X02.00
0

Purchased No

M6061T6B1 000X02 000
6061-T6 Bar 1.00 x 2.00

Location	Loc Qty	Loc Code
ST013	19	
86264	9	
86931	10	
	36.0000	

1
3.5

**

Location	Loc Qty	Loc Code
MAT003	36	
124443	36	

7

OK 13/02/21

DART AEROSPACE LTD		Work Order: 77456
Description: mounting lug		Part Number: 02616-1
Inspection Dwg: 026-0	Rev: 2	Page 1 of 1

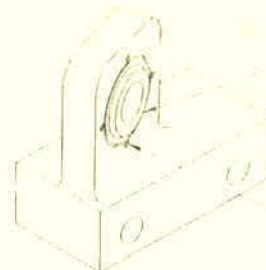
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R .063	$\pm .010$.063	✓			
R .250	$\pm .010$.250	✓			
Ø .8115	$\pm .005/- .000$.8118	✓			
.625	$\pm .010$.623	✓			
1.259	$\pm .010$	1.259	✓			
17°						
2.000	$\pm .010$	2.002	✓			
.622	$\pm .010$					
.511	$\pm .010$					
1.000	$\pm .010$	1.009	✓			
1.125	$\pm .010$	1.123	✓			
.313	$\pm .010$.310	✓			
Ø .257		.258	✓			
.250	$\pm .010$.249	✓			
1.240	$\pm .010$	1.240	✓			
.375	$\pm .010$.375	✓			
.625	$\pm .010$.624	✓			

Measured by: JT	Audited by: JL	Preliminary Approval:
Date: 13-02-20	Date: 15-2-27	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



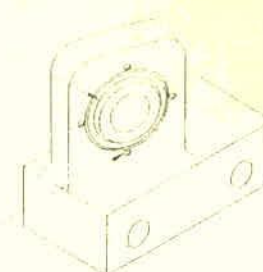
D2616-1 FWD MOUNT LUG

PRESS FIT BEARING D2611

STAKE BEARING 4 PLACES
EACH SIDE

PRESS FIT BEARING D2611

STAKE BEARING 4 PLACES
EACH SIDE



D2616-2 FWD MOUNT LUG

QTY -1	QTY -2	PART NUMBER	DESCRIPTION
X		D2616-1	FWD MOUNT LUG
	X	D2616-2	FWD MOUNT LUG
1	1	D2611	BEARING
1		D2616-1A	LUG
	1	D2616-2A	LUG

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2616-1/2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) D2611 BEARING MUST BE STAKED TO PREVENT TRANSLATION BUT TO ALLOW ROTATION USING DT8019 TOUCH UP PAINT AFTER STAKING

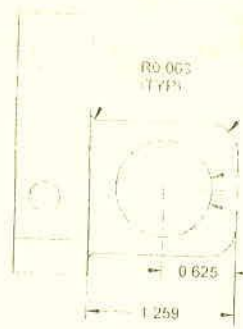
97456 MC
13-02-20

RELEASED
07/11/22

E	UPDATE - DWG SHOW 4 STAKES INSTEAD OF 8 INCORPORATE HAND CHANGES	DC	07.11.22
D	D2611 WAS CBA-6-B2	KE	07.07.21
C	REMOVE D2616-3	BW	07.06.04
B	RE-DESIGN	KE	07.05.20
A	ORIGINAL ISSUE	BW	06.10.20
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	KE	DRAWING NO	REV. E
MFG. APPR	KE	D2616	SHEET 1 OF 2
APPROVED	KE	TITLE	SCALE
DE APPR	KE	FWD MOUNT LUG	1:1
DATE	07.11.22	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	



97457



VIEW A-A

R0.250
(TYP)

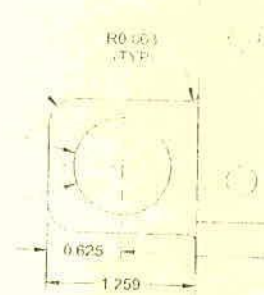
Ø0.8120
Ø0.8115

12
MASK HOLE PRIOR TO PAINT
LEAVE EDGES SHARP

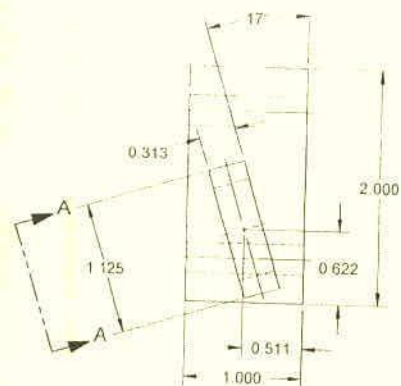
R0.250
(TYP)

Ø0.8120
Ø0.8115

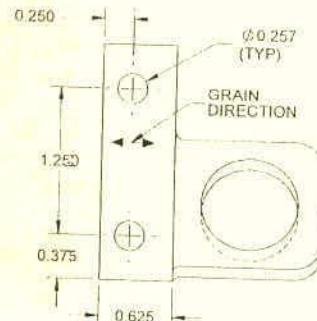
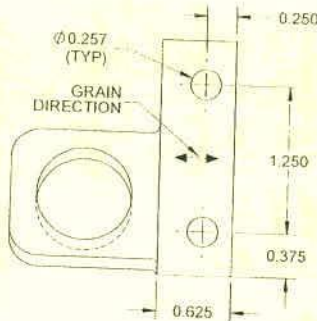
12
MASK HOLE PRIOR TO PAINT
LEAVE EDGES SHARP



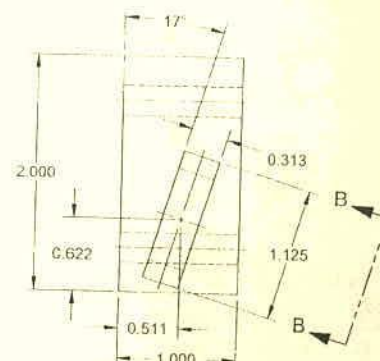
VIEW B-B



D2616-1A LUG



D2616-2A LUG



NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK BEARING HOLE PRIOR TO PAINT
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.14 lbs

RELEASED
07.12.22

DESIGN	EW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	JE	DRAWING NO	REV. E
MFG. APPR.	ME	D2616	SHEET 2 OF 2
APPROVED	ME	TITLE	SCALE
DE APPR	ME	FWD MOUNT LUG	1:1
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